

Technical Information

“Blend in” Technique Transparent Pearleffects (Tri-Coat)

55- Basecoat

B
18c

General:

Due to different spraying techniques and film thicknesses which create different pearleffects, a small spot repair is not possible with transparent pearleffects 55-. A successful repair requires a large-sized blend into the adjacent areas.

It is of great importance that the refinisher uses only the same undercoat color and pearleffect basecoat that were used for the O. E. M. paintwork.

Processing:

1. Pretreatment:

Pretreat damaged part as usual until top coat painting step. Clean the undamaged paintwork that is to accept the blend with:

Silicone and Tar Remover **541-5**

Then scuff with

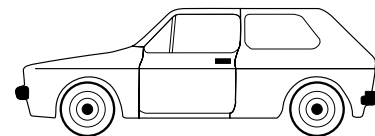
Sandfix
and Sanding Pad **563-808**

After cleaning with water clean again with

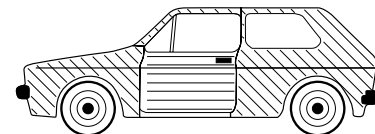
Silicone and Tar Remover **541-5**

2. Color Coat Blend-In

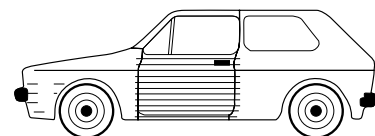
2.1 Pretreatment as per 1. above.



2.2 Mask adjacent areas. Spray repair part (door) with 2 - 3 coats of 55- ground coat to hiding (Pressure = 45 p.s.i.)



2.3 Remove masking from the adjacent areas. Reduce pressure (30 p.s.i.) and spray 55-ground coat into the adjacent areas. Avoid over-spray mist on these areas. Keep spray gun in vertical position.

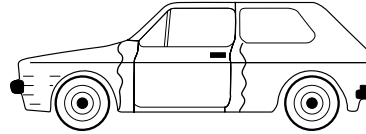


Flash off for 15 min. at 68°F/20°C.



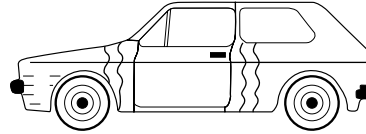
2.4 First coat:

Spray 55- pearleffect into the adjacent areas extending it 3-4 inches beyond the 55-Line ground coat. **No** mist coats.



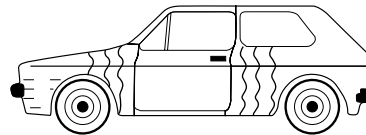
2.5 Second coat:

Spray 55- pearleffect extending it 3-4 inches beyond the first coat. **No** mist coat.



2.6 Third coat:

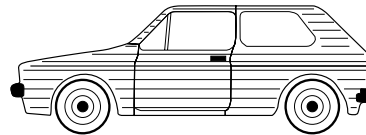
Spray 55- pearleffect extending it 3-4 inches beyond the second coat. **No** mist coat.



Flash off 20 min. at 68°F/20°C.

3. Clear Coat

A. Apply 1–2 coats of 923- clear* onto the full panel (door) and the adjacent parts.



Note: Color tone should be evaluated by making a let down panel prior to painting. This panel should show the finished color when using between 1 and 5 coats of mid coat. Compare the panel to the car and note which section is the closest match. Use the same number of coats on the car as the let down panel has.

* Refer to specific clearcoat information in section EC to determine the appropriate clearcoat for each topcoat system.